

Date: Monday, 02/02/2009 3:46:15 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BASKET BASE ASS'Y (A119)
<b>Job Number</b> : 45425B	
<b>Estimate Number</b> : 12431	
<b>P.O. Number</b> :	<b>Part Number</b> : D3516041
<b>This Issue</b> : 02/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3516 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 37596B	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/03/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.02.03</u>	
<b>Comment</b> : EST rev. A 06.05.31 Preliminary EC EST rev. b 06.07.27 updated EC Est Rev:C 08-02-25 ECN 1138P DD verified by: LL Est Rev:D 08-03-18 ecn 1136 DD verified by:	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D34421	Shim
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Shim

Batch: B45226

PD 09.03.04

2.0	D2581	Mounting Bracket
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Batch: B43800

PD 09.03.04

3.0	D351611	Clevis
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**Comment:** Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

CLEVIS

batch: B37619

PD 09.02.19

4.0	D351613	Clevis
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

CLEVIS

batch: B37620

PD 09.02.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 45425B

Part Number: D3516041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D23273	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Batch: B44365

PD 09-02-19

①

6.0	D22323	Basket Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Batch: B42075

PD 09-03-04

7.0	D31661	Basket Hoop
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RIB

Batch: B45779  
B44996

SAD 09-02-09

①

8.0	D37251	Hoop
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HOOP

batch B38169

PD 09-02-18

①

✓ 9.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 53.1825 f(s)/Unit Total : 53.1825 f(s)

AISI 304 SQ Tube .75x.75x.065W

Batch: M110561 (50.1825) ~~M110011 (3.000)~~

SAD 09-02-09

①

10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3516-1 as per dwg D3516

SAD 09-02-09

①

2-Cut rib D3516-3 as per dwg D3516

SAD 09-02-09

①

3-Cut rib D3516-5 as per dwg D3516

SAD 09-02-09

①

4-Cut rib D3516-7 as per dwg D3516

SAD 09-02-09

①

5- Cut rib D3516-15 as per dwg D3516

SAD 09-09-09

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 45425B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6-Cut rib D3516-9 from D3166-1 (4) using DT8365 jig

PD 09-02-19

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3516

PD 09-02-19

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-02-26

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/02/26 (+)

14.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 60.0000 sf(s)/Unit Total : 60.0000 sf(s)

Expanded Metal Flat Stainless steel

Batch: 2110861

SAD 09-02-26

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516

2-Cut expanded metal for base ends as per dwg D3516

3-Weld expanded metal to base as per dwg D3516

PD 09-03-05

16.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-03-05

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/03/05 (+)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 45425B

Part Number: D3516041

Job Number:



Seq. #: Machine Or Operation: Description :

18.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

*m110 939 Pressure Wash*

*cmd/br 09-03-11*

1ST COAT:

START TIME:

*10:00*

OVEN TEMPERATURE:

*400°*

FINISH TIME:

*10:30*

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

*cmd/br 09-03-11*

2ND COAT:

START TIME:

*11:00*

OVEN TEMPERATURE:

*400°*

FINISH TIME:

*11:30*

*cmd/br 09-03-11*

19.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*09-03-11*

*(X)*

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*PPD 45425*

*09/3/18*

21.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/03/19*

Job Completion



*MF 09-03-18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

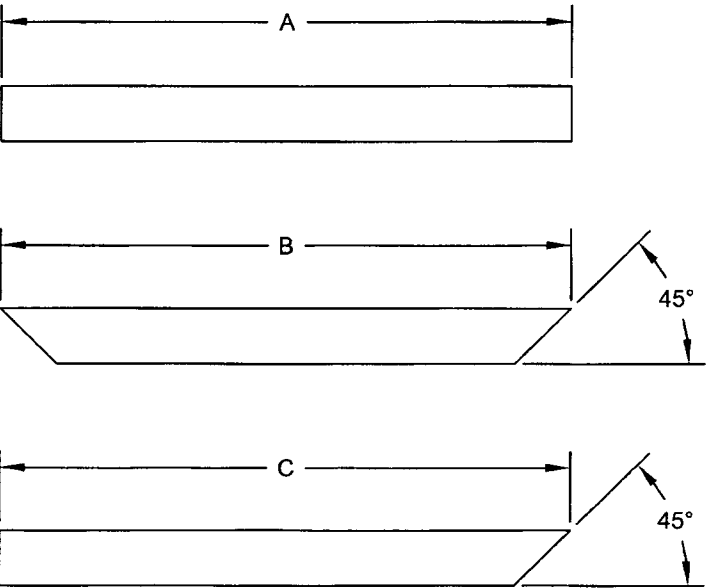
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	LENGTH C	DESCRIPTION
D2232-3	2	N/A	N/A	N/A	HINGE PLATE
D2327-3	2	N/A	N/A	N/A	BUSHING
D2581	2	N/A	N/A	N/A	MOUNTING BRACKET
D3442-1	2	N/A	N/A	N/A	SHIM
D3516-1	2	—	102.00	—	RIB
D3516-3	2	—	—	2.70	RIB
D3516-5	8	26.75	—	—	RIB
D3516-7	3	45.50	—	—	RIB
D3516-9	4	N/A	N/A	N/A	RIB (MAKE FROM D2235-3)
D3516-11	6	N/A	N/A	N/A	CLEVIS
D3516-13	4	N/A	N/A	N/A	CLEVIS
D3516-15	2	—	—	19.32	RIB
D3725-1	2	N/A	N/A	N/A	HOOP

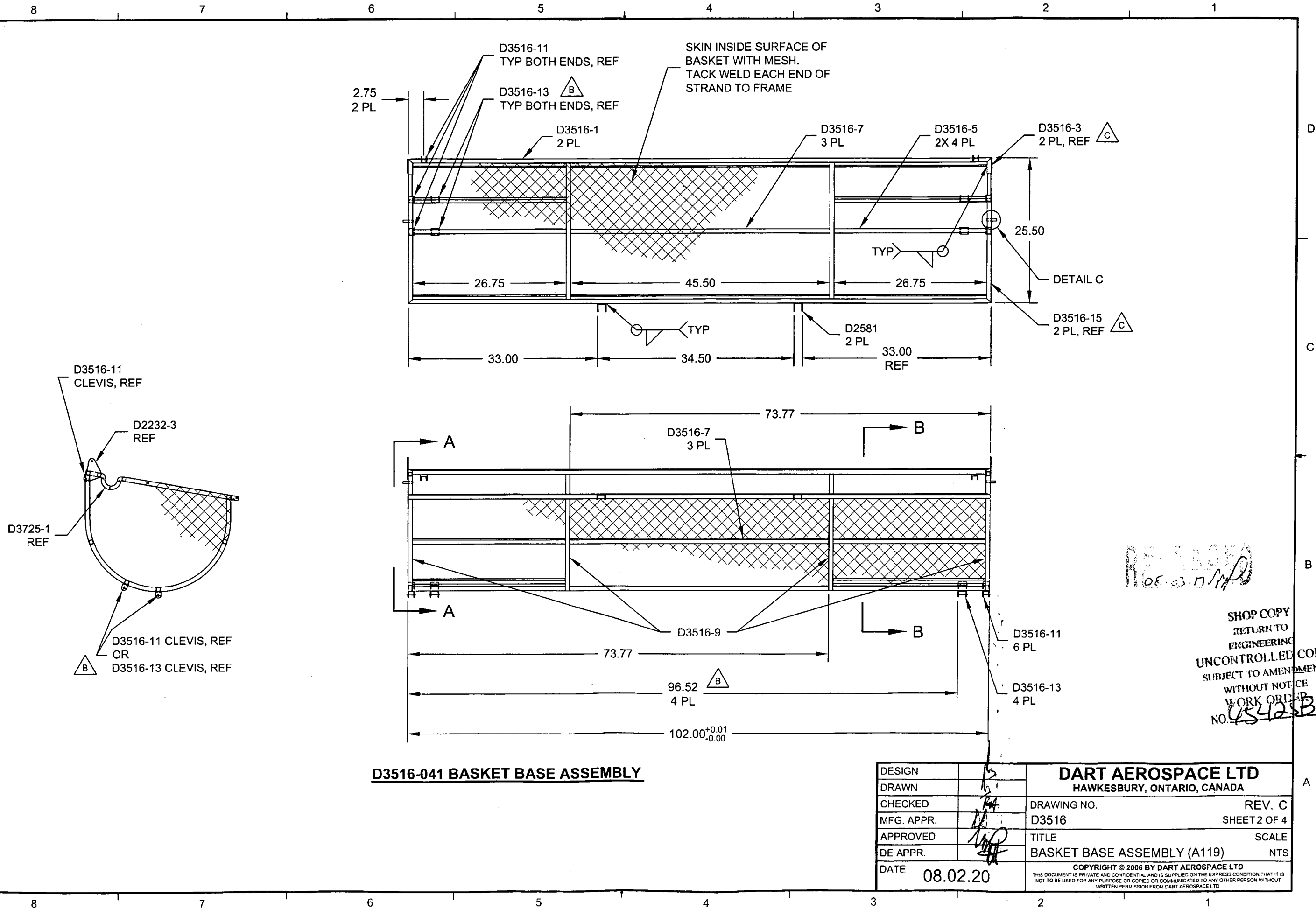


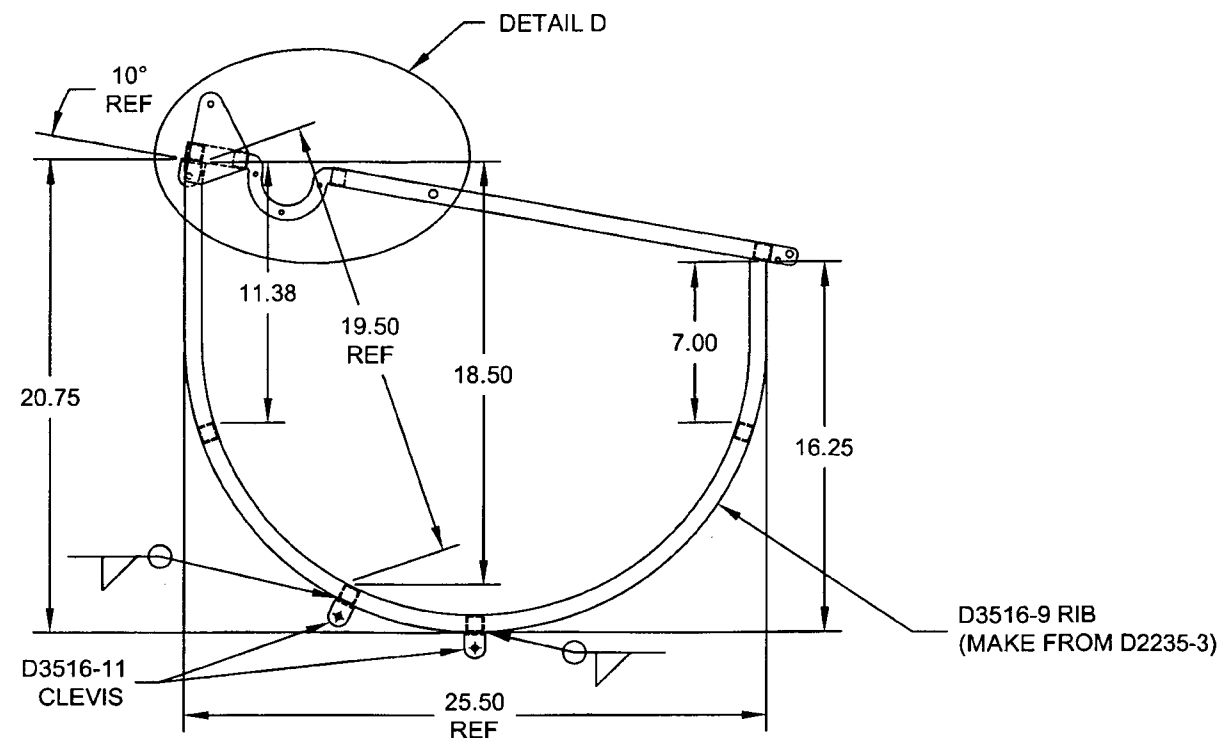
D3516-041 BASKET BASE ASSEMBLY NOTES:

- 1) MATERIAL:  
FRAME - AISI 304/316 STAINLESS STEEL SQUARE TUBING, 3/4 X 3/4 0.065 WALL  
(REF. DART SPEC. M304TS0.750W.065)  
MESH - 3/4-16F EXPANDED STAINLESS STEEL  
(REF. DART SPEC. M304EX0.75-16F)
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 75 lbs
- 8) WELDING: PER DART QSI 004

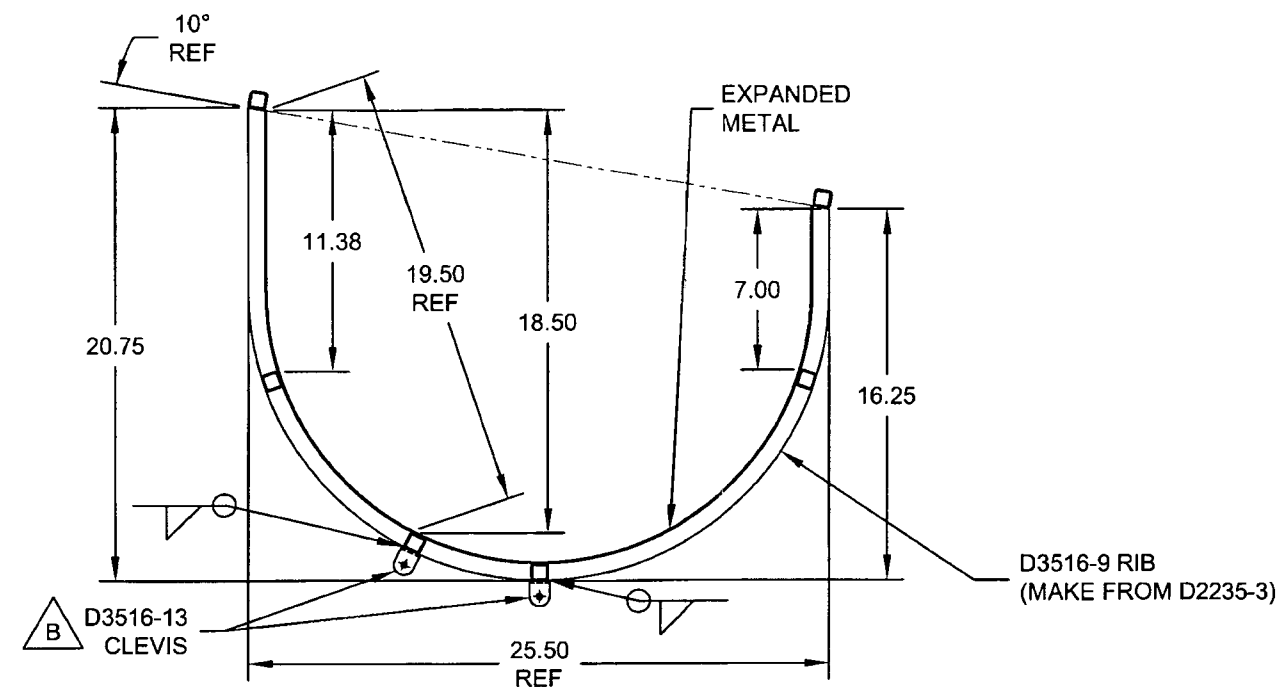
C	ADD D3725-1 (ZNA7-3) AND D3516-15 (ZNA5-3), QTY.(1) PER END OF BASKET BASE; SHORTEN D3516-3 (REF. ECN#1136); REASON: CUSTOMER REQUEST	MB	08.02.20
B	ADD QTY.(4) D3516-13; QTY.(6) D3516-11 WAS QTY.(1) SEE TR-D119-756-1 REV. A	MB	06.07.25
A	NEW ISSUE	MB	06.06.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<b>DART AEROSPACE LTD</b> <b>HAWKESBURY, ONTARIO, CANADA</b>		
DRAWN			
CHECKED	DRAWING NO.	REV. C	
MFG. APPR.	D3516	SHEET 1 OF 4	
APPROVED	TITLE	SCALE	
DE APPR.	BASKET BASE ASSEMBLY	NTS	
DATE	08.02.20	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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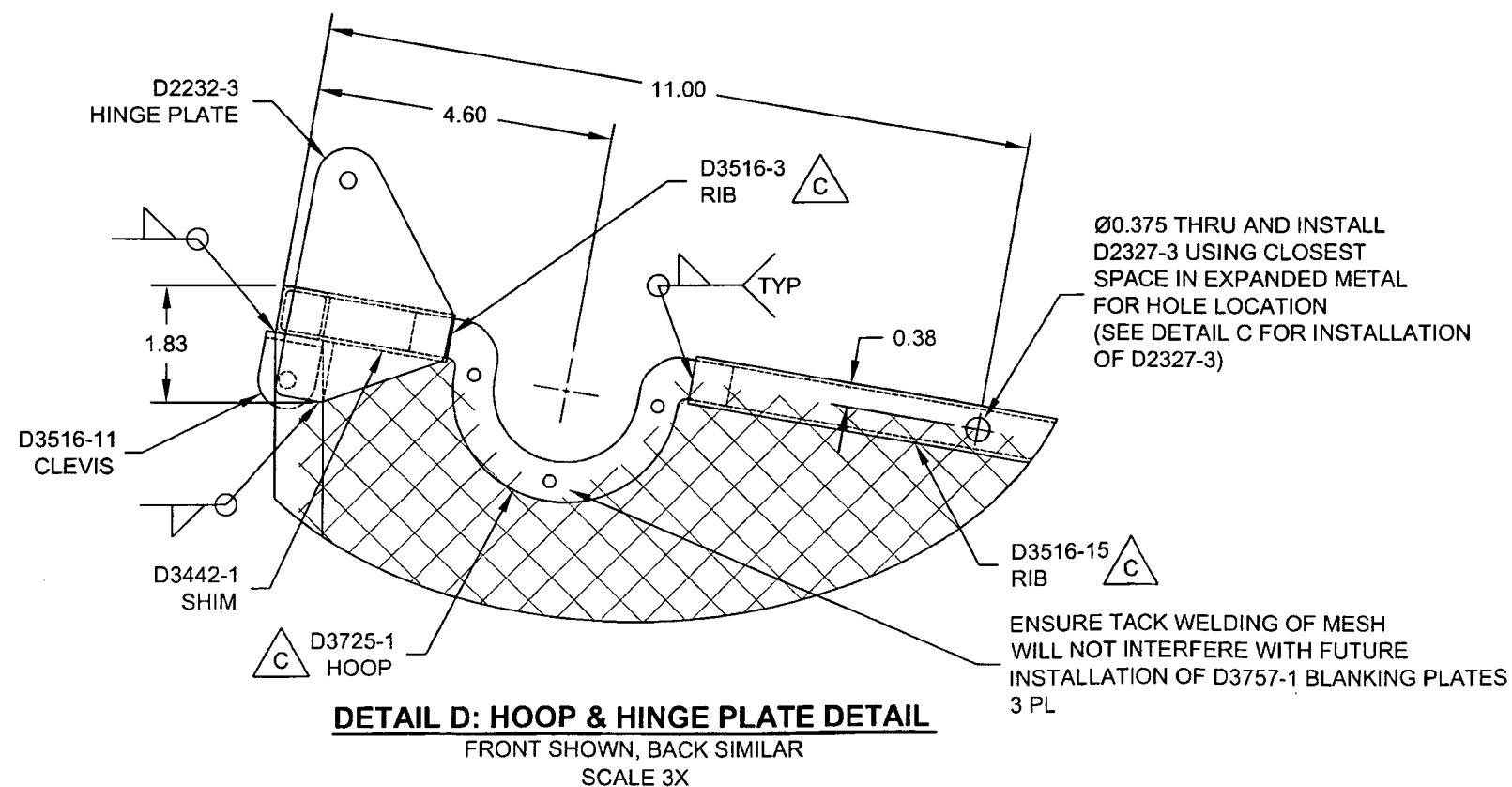




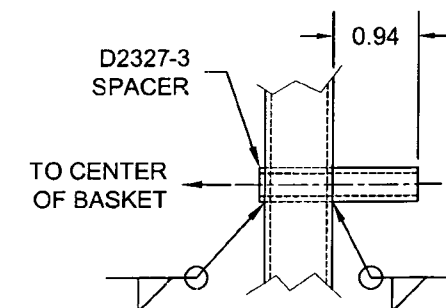
**SECTION A-A: END RIB DETAIL**  
(MESH NOT SHOWN FOR CLARITY)  
TYP BOTH ENDS



**SECTION B-B: CENTER RIB DETAIL**  
2 PL



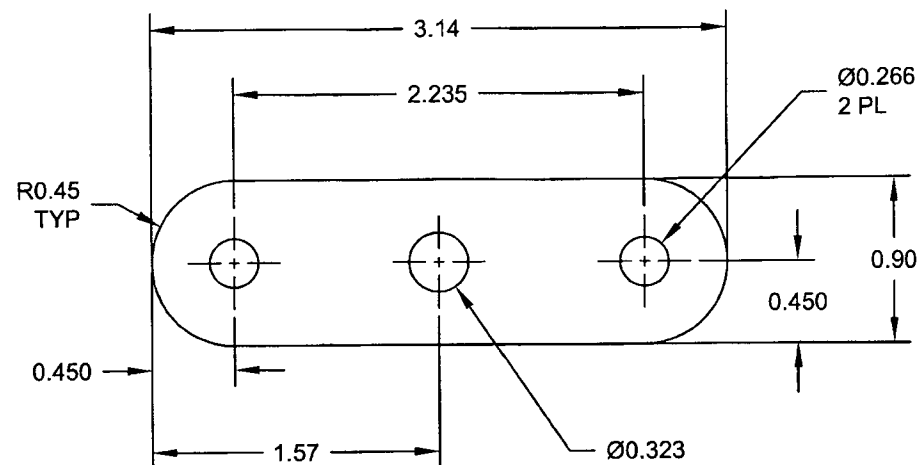
**DETAIL D: HOOP & HINGE PLATE DETAIL**  
FRONT SHOWN, BACK SIMILAR  
SCALE 3X



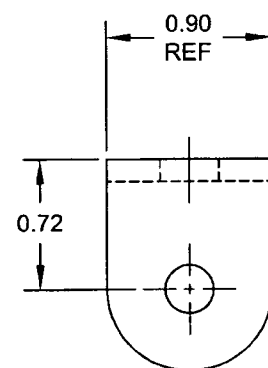
**DETAIL C: SPACER INSTALLATION**  
SCALE 4X

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY	NTS
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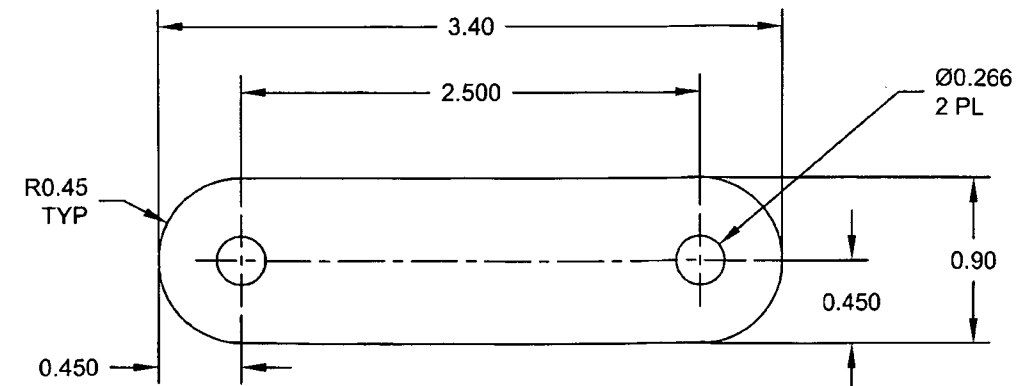
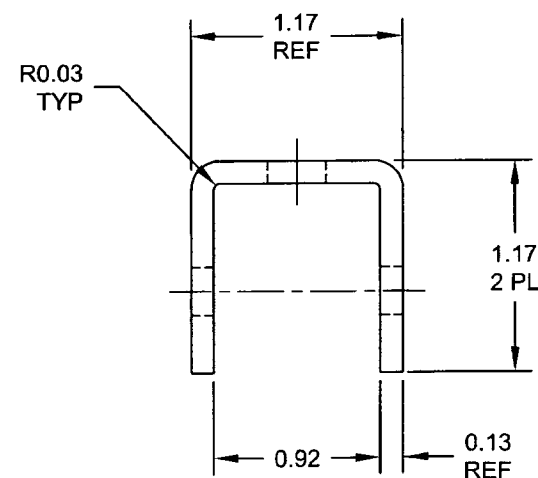
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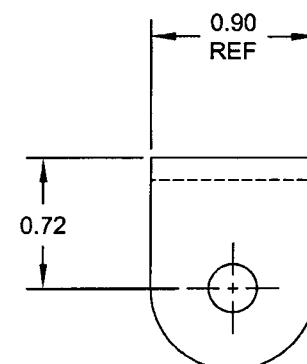
1 D3516-11F CLEVIS FLAT PATTERN



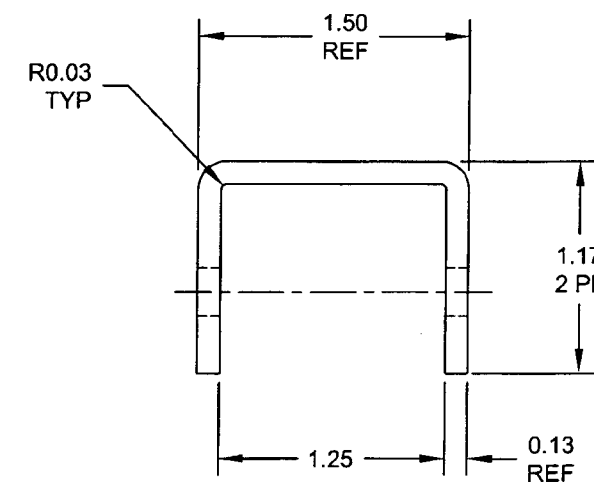
D3516-11 CLEVIS BENDING DETAIL  
(MAKE FROM D3516-11F)



1 D3516-13F CLEVIS FLAT PATTERN



D3516-13 CLEVIS BENDING DETAIL  
(MAKE FROM D3516-13F)



**D3516-11/-13 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524, 11 GAUGE (0.125 THICK)  
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3516-11 = 0.09 lbs  
D3516-13 = 0.10 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (A119)	NTS
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